

Date: Tuesday, 22/04/2008 3:53:32 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 38759
 Estimate Number : 12737
 P.O. Number :
 This Issue : 22/04/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D353513
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3535 REV B
 Previous Run : 37584 Drawing Revision : B
 Material :
 Due Date : 02/05/2008 Qty: 16 Um: Each
 Written By :
 Checked & Approved By : JLD 08.4.23
 Comment : Est Rev:A New Issue 07-02-15 JLM
 Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.8930 sf(s)/Unit Total : 14.2884 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 107744 IB 8-4-25

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

IB 8-4-25

(16)

2-Deburr if necessary

IB 8-4-25

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-4-25

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SB 08/04/28 (16)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326
 2-Form joggle as per Dwg D3535 using Jig DT8158Identify as D3535-13

SB 08/05/13 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 38759

Part Number: D353513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soot 08/05/14 (+16) count 30 min

7.0

POWDER COATING

POWDER COATING



M 105642



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



9/2



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15

(X16)

15/05/2008
S.251 13.14
#1 323.0 F
#2 338.75 F
#3 0353513 F
#4

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-16*

9/2

08-05-15

(X16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/16

Job Completion



MF 08-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

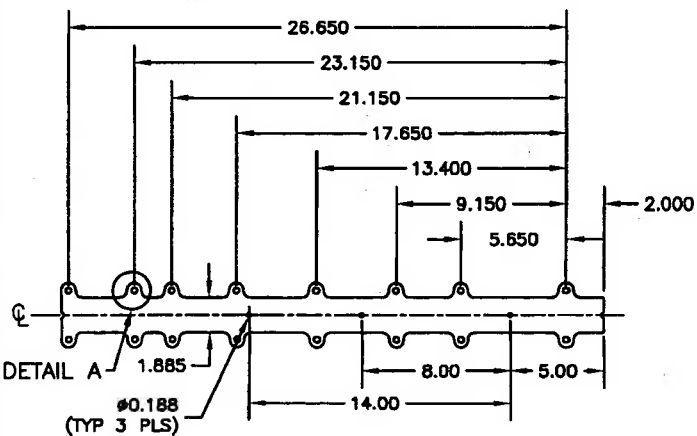
NOTE: Date & initial all entries

DART

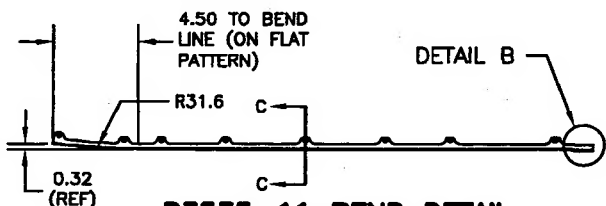
RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		



D3535-11F FLAT PATTERN

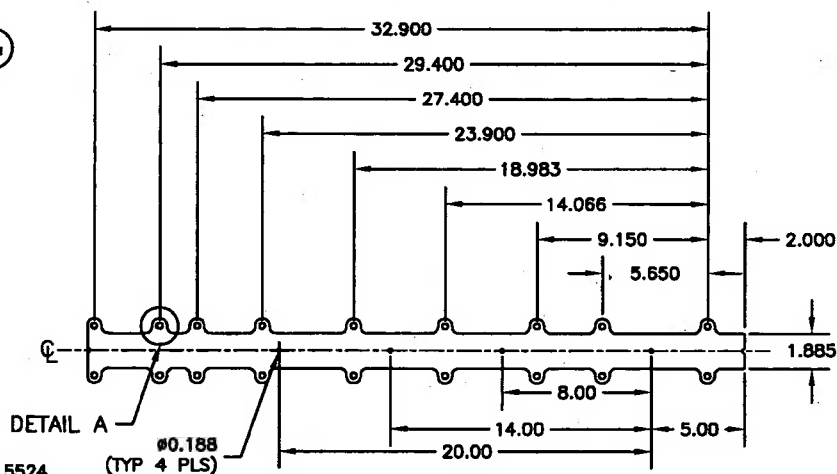


D3535-11 BEND DETAIL

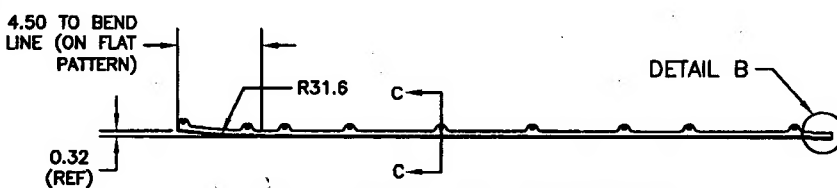
SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38754

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-13F FLAT PATTERN

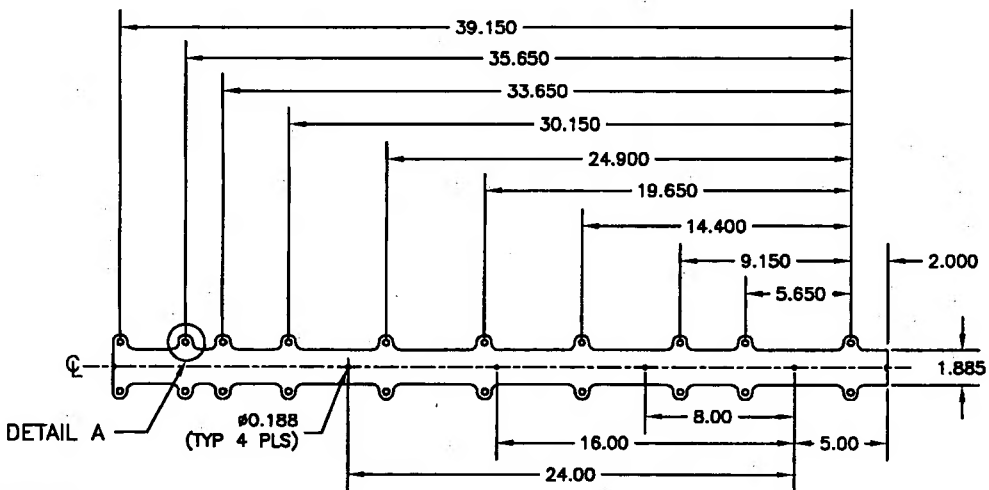


D3535-13 BEND DETAIL

DART

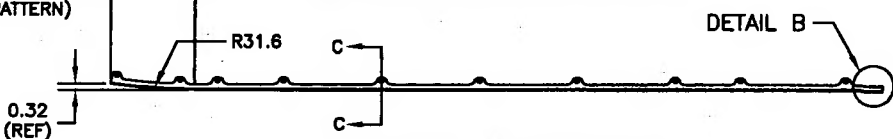
RELEASED
67.04.24 -11-

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7
	SCALE 1:10	



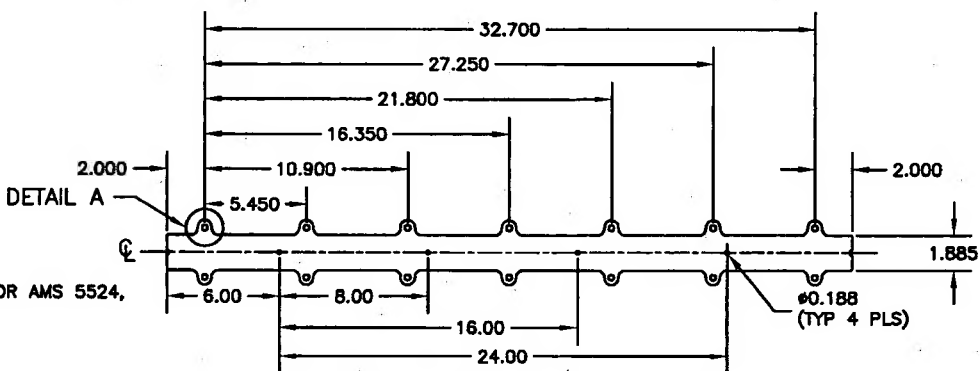
4.50 TO BEND
LINE (ON FLAT
PATTERN)

D3535-15F FLAT PATTERN

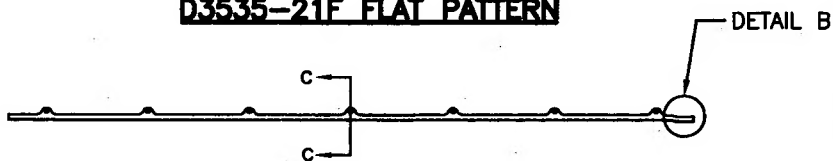


D3535-15 BEND DETAIL

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D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

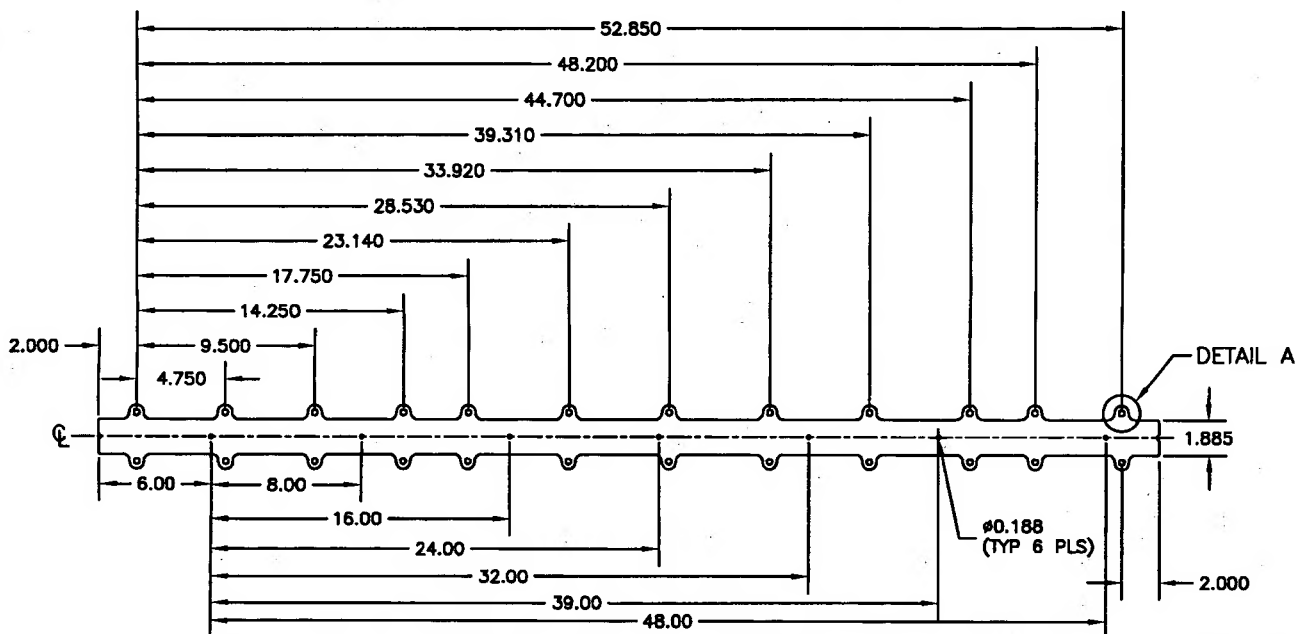
NOTES

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RELEASED

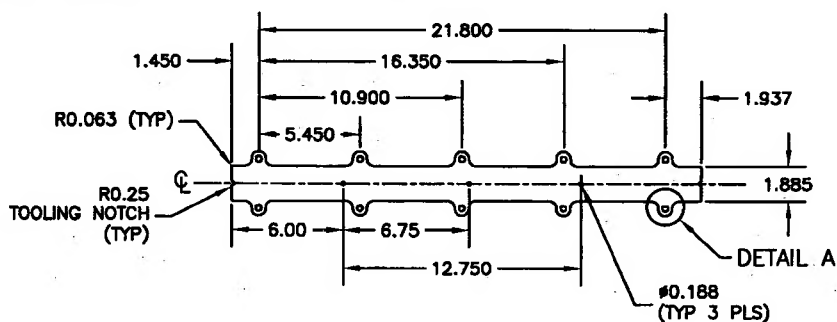
07.04.24



D3535-23F FLAT PATTERN

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D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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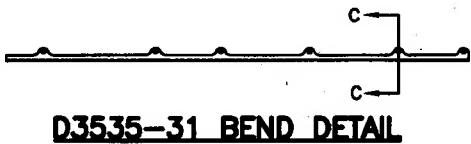
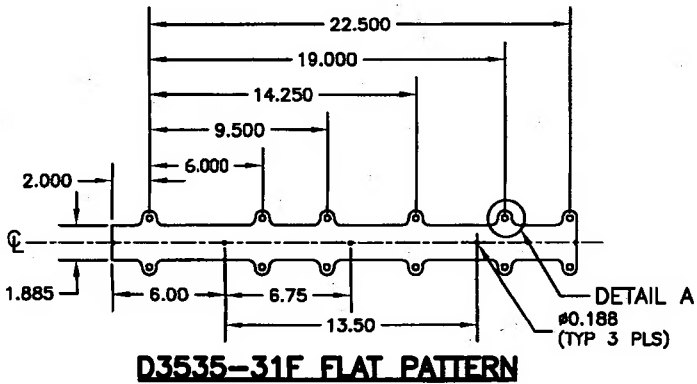
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	SHEET 3 OF 7	REV. B

DART

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DATE	07.04.17	TITLE	D3535	REV. B
		WEARSHOE		SHEET 4 OF 7
		SCALE	1:10	

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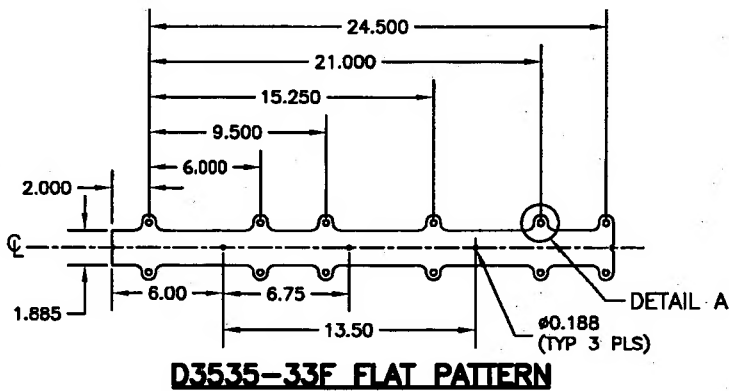
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NOTES

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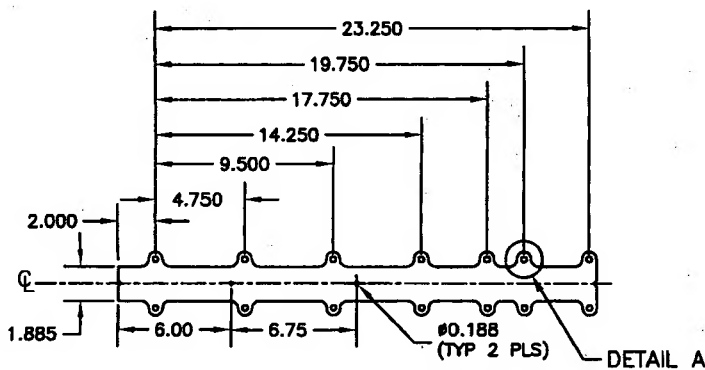


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07.04.14

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DATE	07.04.17	TITLE	D3535	WEARSHOE
				SCALE
				1:10
				SHEET 5 OF 7
				REV. B



D3535-35F FLAT PATTERN

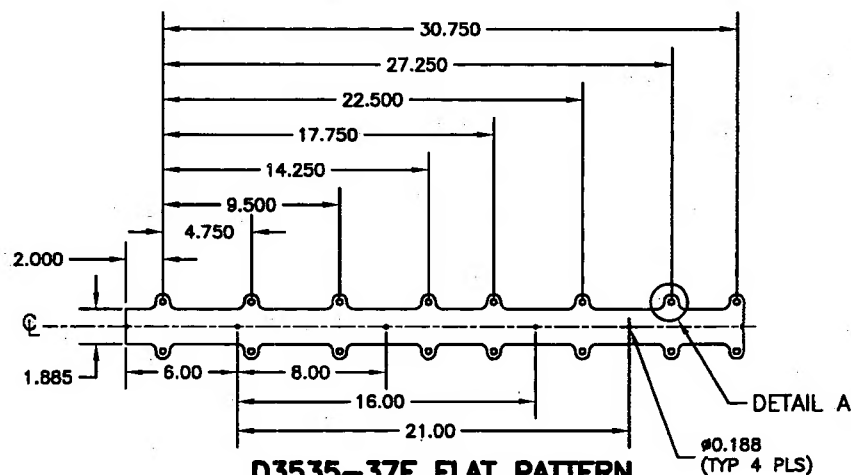


D3535-35 BEND DETAIL

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NOTES

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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-37F FLAT PATTERN

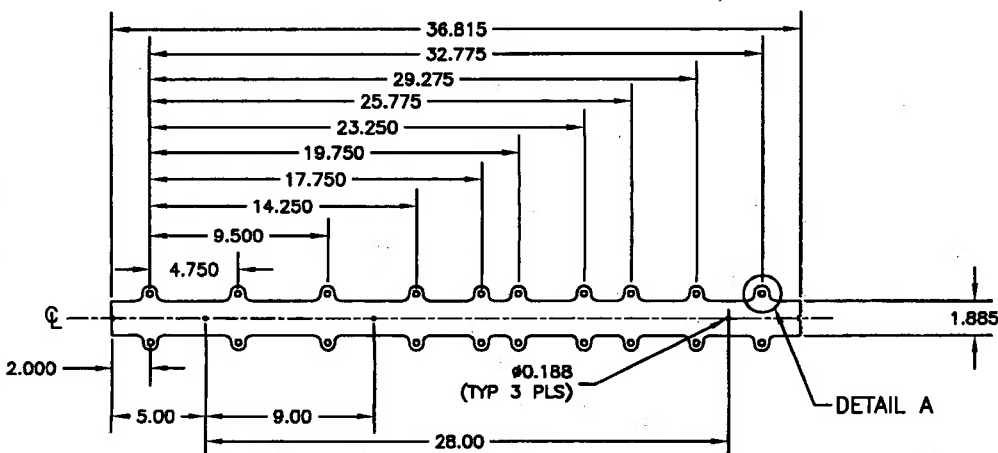


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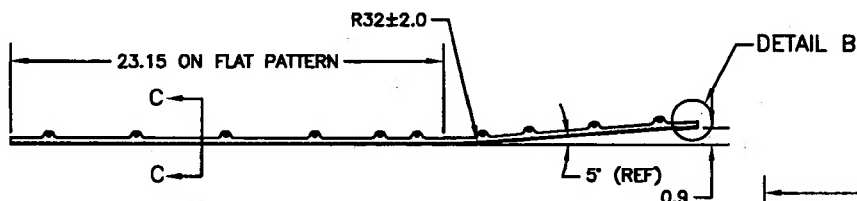
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07.04.24



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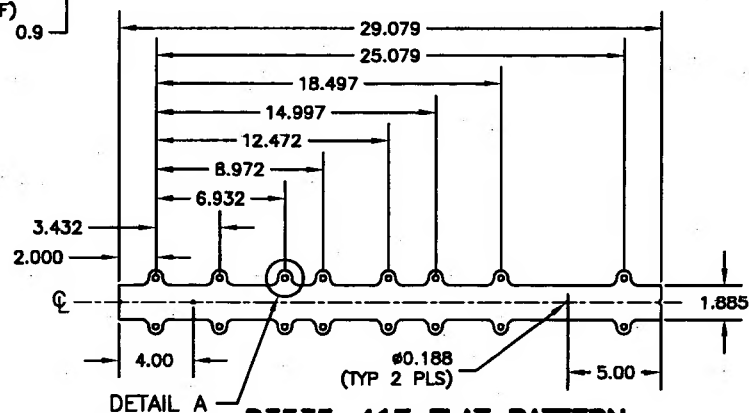


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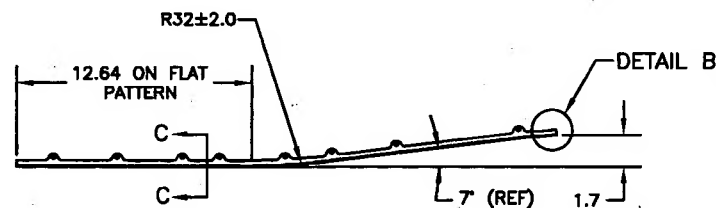
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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D3535-41F FLAT PATTERN



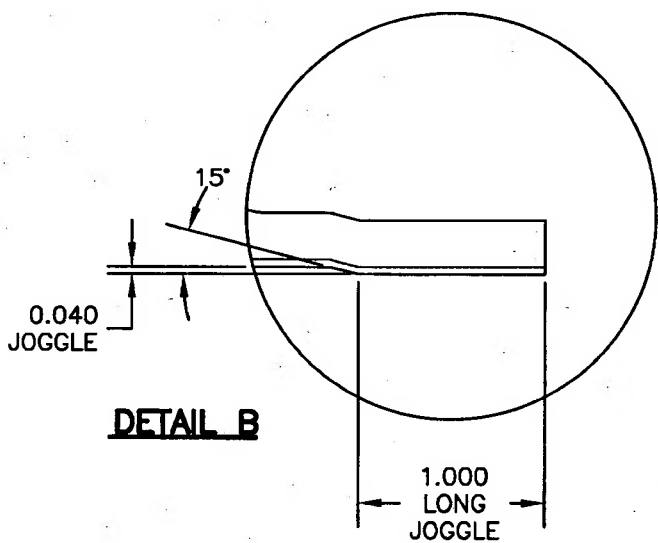
D3535-41 BEND DETAIL

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C.B.	M	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	
DATE	TITLE	SHEET 6 OF 7	
07.04.17	WEARSHOE		
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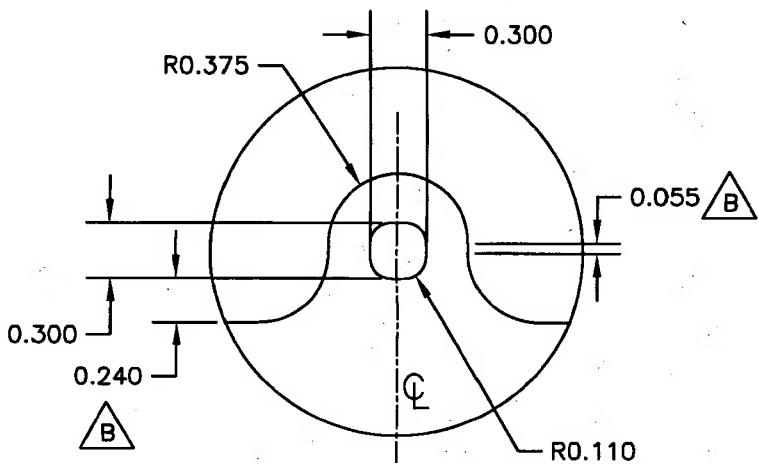
DART

DESIGN	C.B.	DRAWN BY	AH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
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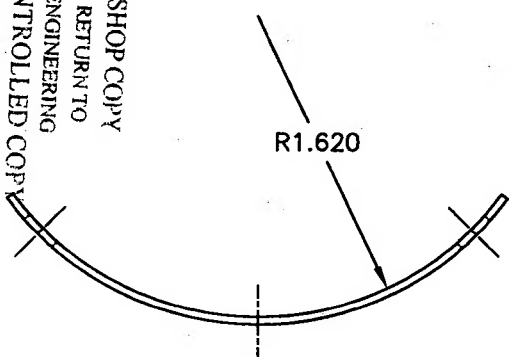
RELEASED
07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

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